

Rush

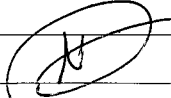
Work Order ID 132122

132122

Page 1

Tuesday, April 28, 2015 8:27:23 AM

Item ID: D4964-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Step Leg
Start Date: 4/28/15 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 4/30/15 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan:  Date: 154-28 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4964	A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

(6) 12/15/04/28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(6) 12/15/04/28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 132122

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132122

Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>6</u>			DAS 38 9-89 APR 28 2015
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00			DAS 36 9-89	<u>6</u>			APR 28 2015
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00			DAS 30 9-89	<u>6</u>			APR 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 132122

Tuesday, April 28, 2015 8:27:23 AM

132122

Page 3

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 Revision ID: Stop *NS2*
 Item Name: Step Leg
 Start Date: 4/28/15 Start Qty: 6.00 *6* Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>6-A</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION : GA								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ APR 29 2015

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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OTHER : ☐					

Picklist Print

Tuesday, April 28, 2015 8:27:28 AM

Page 1

Work Order ID: 132122

132122

Parent Item: D4964-1

D4964-1

Parent Item Name: Step Leg

Start Date: 4/28/15

Required Date: 4/30/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.11.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

sf

213.6918

6

M6061T6S 080

DC15/04/28

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT009

96

m132037

96

MAT020

117.6918

m130530

9.6

m130561

60.0918

m132099

48

7.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	132122
Description: Step leg		Part Number:	4964-1
Inspection Dwg: 4964 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

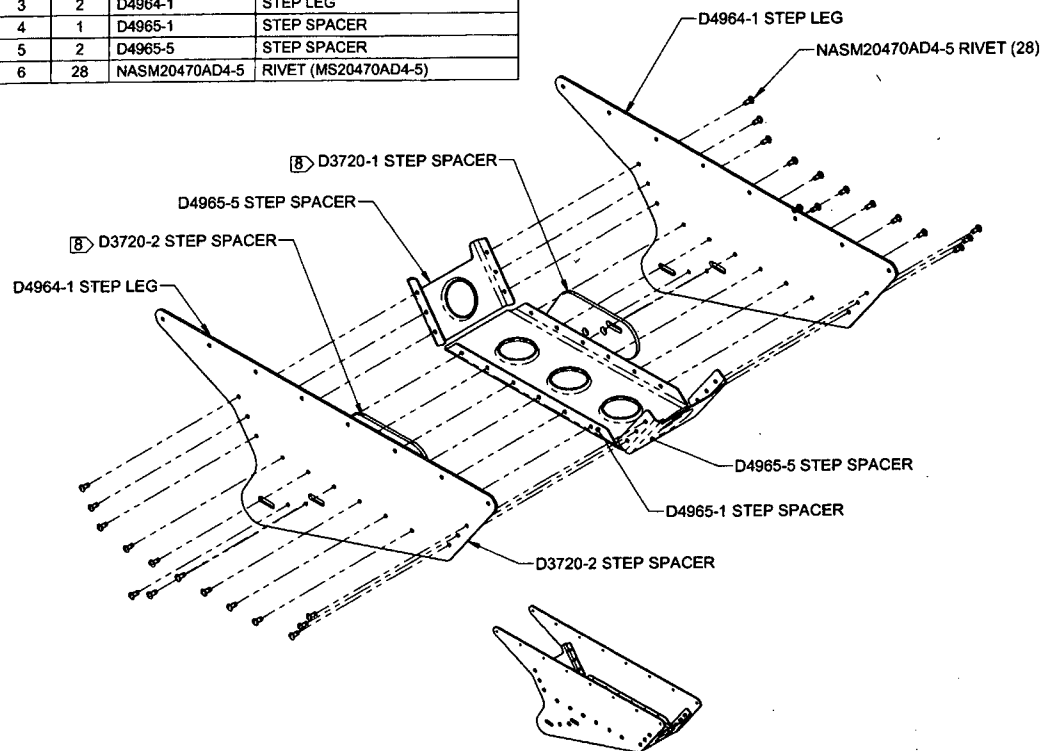
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	-.005 +.005	Ø .129	/		V-D-52	
.213	+/- .010	.212	/		Tap	
.750	+/- .010	.749	/			
.354	+/- .010	.346	/			
1.802	+/- .010	1.802	/			
2.416	+/- .010	2.418	/			
3.030	+/- .010	3.031	/			
3.304	+/- .010	3.308	/			
4.177	+/- .010	4.178	/			
4.699	+/- .010	4.703	/			
5.169	+/- .010	5.174	/			
5.478	+/- .010	5.482	/			
6.69	+/- .030	6.696	/			
2.804	+/- .010	2.596	/			
.080	+/- .010	.078	/			

Measured by:	Dr	Audited by:	SW	Preliminary Approval:	
Date:	15/04/28	Date:	APP 28 7015	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4964-041	MID STEP LEG ASSY
1	1	D3720-1	STEP SPACER
2	1	D3720-2	STEP SPACER
3	2	D4964-1	STEP LEG
4	1	D4965-1	STEP SPACER
5	2	D4965-5	STEP SPACER
6	28	NASM20470AD4-5	RIVET (MS20470AD4-5)

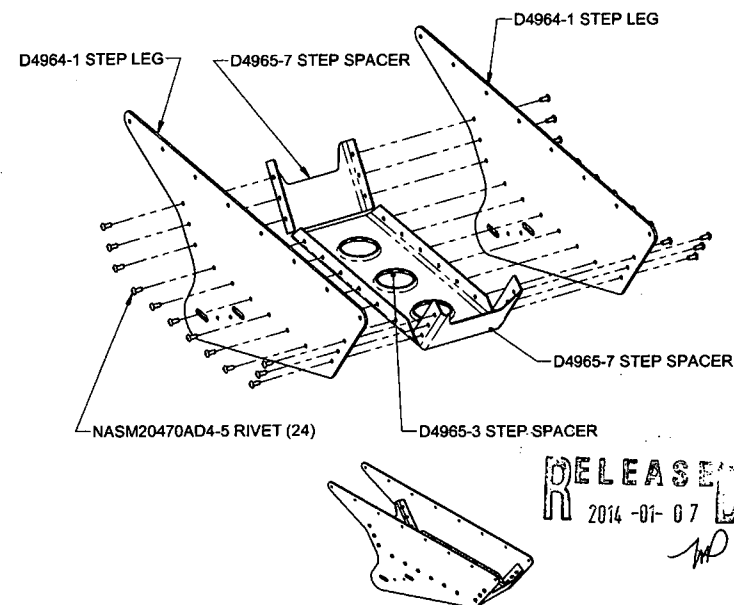
ITEM	QTY -043	P/N	DESCRIPTION
	X	D4964-043	MID STEP LEG ASSY
1	2	D4964-1	STEP LEG
2	1	D4965-3	STEP SPACER
3	2	D4965-7	STEP SPACER
4	24	NASM20470AD4-5	RIVET (MS20470AD4-5)



D4964-041 MID STEP LEG ASSEMBLY
(FOR D350-591-121/-122 STEP MOD KITS)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4964-041" OR "D4964-043" PER DART QSI 044 6.1
- 7) WEIGHT: 0.44 lbs
- 8) D3720-1/-2 STEP SPACERS MOUNTED WITH COUNTERSUNK HOLES TO THE INSIDE OF ASSEMBLY. GRIND RIVETS FLUSH TO INSIDE SURFACE.



D4964-043 MID STEP LEG ASSEMBLY
(FOR D350-591-213/-214/-311/-312 STEP MOD KITS)

A NEW ISSUE		DB	13.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS	MID STEP LEG ASSY	
DATE	13.12.18	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

HS-4-28

